

GR

Date: Monday, 02/03/2009 11:25:55 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING PLATE
Job Number : 46200	
Estimate Number : 13714	
P.O. Number :	Part Number : D36945
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D3694 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 44716	Material :
Written By :	Due Date : 16/03/2009 Qty: -6 Um: Each
Checked & Approved By : <u>JLD 09.03.08</u>	
Comment : Est Rev:A new issue 09-01-12 DD verified by:JLM Est Rev:B 09-02-20 rev.c asper dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
Comment: Qty.: 0.7094 sf(s)/Unit Total : 4.2563 sf(s) 6061-T6 .125 Sheet batch: <u>109058</u> <u>HB 9-3-9</u> <u>110405 x2 -1-4</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3694 Dwg Rev: <u>C</u> <u>HB 9-3-9</u> Prog Rev: <u>C</u> 2-Deburr if necessary <u>HB 9-3-9</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Counter sink holes 0.204" (4 places) as per dwg D3694 2- deburr		

FF 09/03/12

7

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:25:55 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING PLATE

Job Number: 46200

Part Number: D36945

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



09/03/12 (7)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(X7)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMD/FR 09/03/12

(PTO)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(X7)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(17x)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location 255

9/3/12

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09/03/12 m 109648

(X7)

Start time: 13:05

Temp: 320°

Finish: 13:35

B M 109648

UMD/FR

09/03/12

powder coat grey
per QSI 005 4.3.5.6 : packaging.

W/O: 46200		ESTIMATE: 13714		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/03/12	7.0	Part needs to be powder coated after machine, as per dwg. Start Temp Finish Add. Powder coat grey 4.3.5.6 perm change.				09/03/18		09/03/12	09/03/12

Part No: D3694-5

PAR #: N/A

Fault Category: Prod / Finishing

NCR: Yes No

DQA: D

Date: 09/03/20

Resolution: re-work

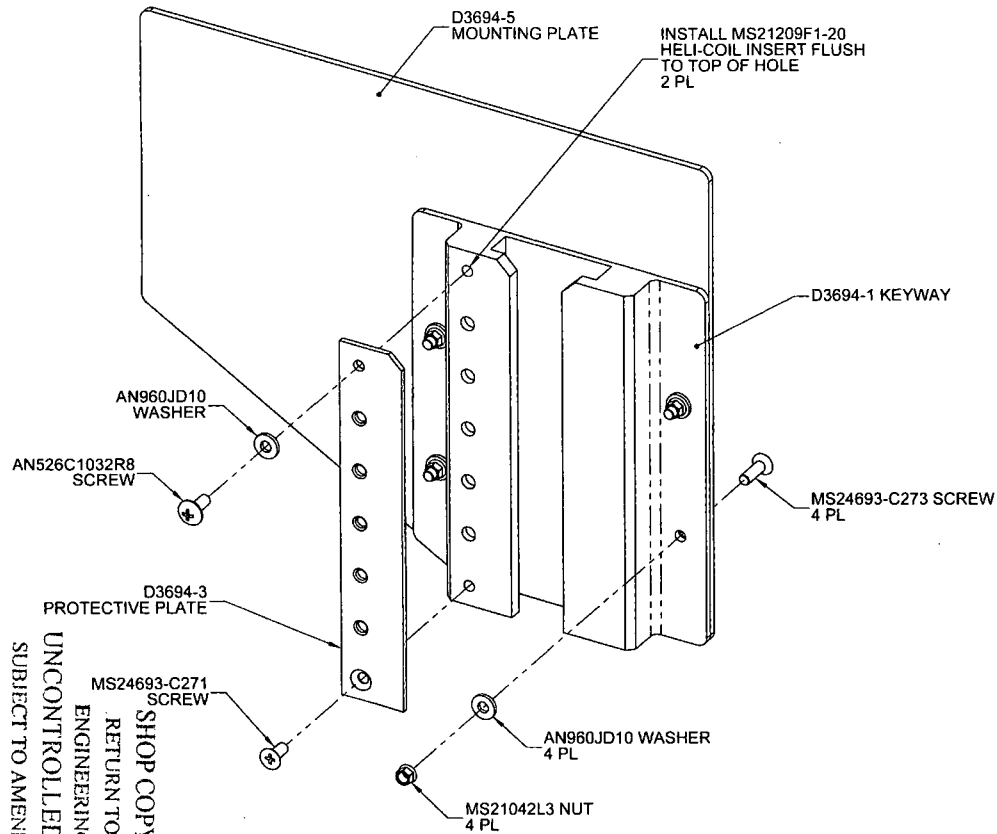
Disposition: re-work

QA: N/C Closed: D

Date: 09/03/20

NCR: 46200		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/17	7.0	After machine it was noticed that there was a 0.020" piece hole in 1 corner. Noticed by Finishing. R.C. Machine Malfunction. Water Jet		Buff & remove machine - fill hole with weld per Q51004: grind flush. Touch up area with machine per Q51005	09-03-17			

NOTE: Date & initial all entries



D3694-041 MOUNTING PLATE ASSY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

RELEASED
07/12/05 MB

C	REDESIGNED ITEM 11; REVISED ITEM 12: DIM Ø0.204 WAS Ø0.234 (ZN D6-3); ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1); REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY. 1 MS24693-C271 SCREW WAS QTY. 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3). REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

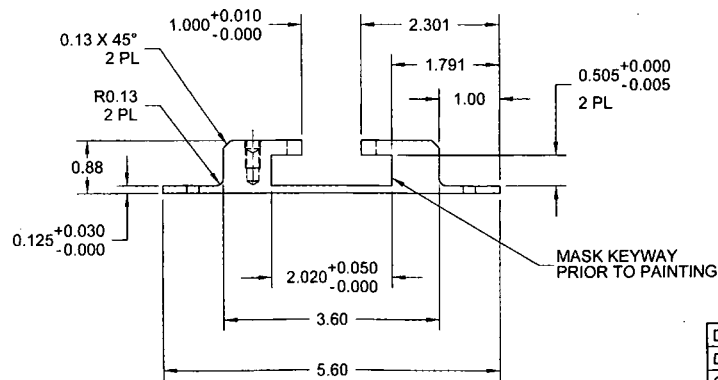
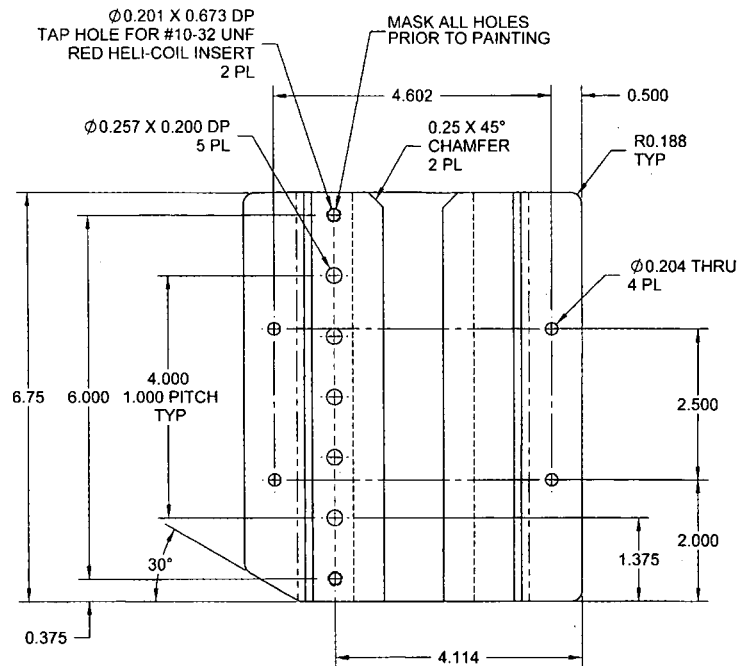
- D3694-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.70 lbs

NO. 10200
WORK CENTER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3694** REV. C
SHEET 1 OF 4
TITLE **MOUNTING PLATE ASSY** SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD



D3694-1 KEYWAY

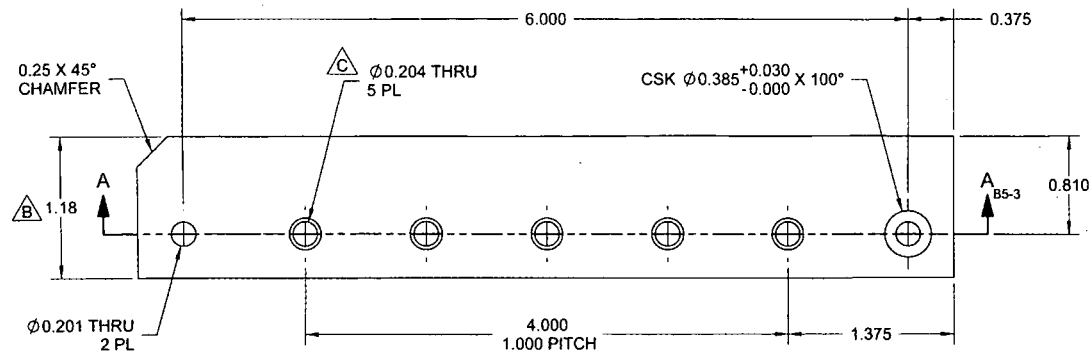
D3694-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

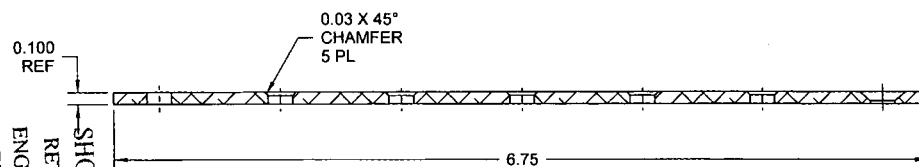
RELEASED
09/05/10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.11.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 00000



D3694-3 PROTECTIVE PLATE



SECTION A-A C3-3

NO 116200
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),
PER PER AMS 5513 OR AMS 5524
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

RELEASED
07/05/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

